

March-05-14 7:35:21 AM

Page 1

Large Fab

1-Weld one end cap and (2) lugs as per Dwg D2842
2-Grind end cap weld flush

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140	Chemical Conversion Coat per QSI005 4.1	0.00	
140			
HandFinish	Memo	0.00	<u>2</u> <u>7/6/14-8-11</u>
Hand Finishing			

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[illegible]

Work Order ID 114439

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114439

Page 4

Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly RH, 206 Float
Start Date: 3/05/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/19/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
185	Pressure Wash per QSI005 4.3	0.00							
185									
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:10 OVEN TEMPERATURE: 320 FINISH TIME: 8:40								

DAS 34 6-89

DQA: dwf Date: 14/07/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: dwf Date: 14-7-3

Work Order update only ☐

Work Order: <u>114439</u> Part No. <u>D2842-042</u> NCR No. <u>14-4007</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input checked="" type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input checked="" type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input checked="" type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-04-09		1	Scrap due to extrusion being 0.1mm wall on one side Supplier NCR # 14-3683	L 14-04-09	Scrap 1 No replace \$26.83	DAS 19 9-89 14-04-09	DAS 27 9-89 14/11/14	DAS 27 9-89 14/11/14
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00				1	2	20	14/04/10
200									
QC	Memo	0.00							
Quality Control									
210	HandFinishing	0.00				1	2	20	14/04/11
210									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: 128623								
220	QC5- Inspect part completeness to step on W/O	0.00				1			
220									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
14/4/14

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Item ID: D2842-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 3/05/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/19/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

Handwritten: 112873
 DAS 06 9-89
 (17)

Handwritten: 14/6/23
 MF
 14-6-19

Picklist Print

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Page 1

Work Order ID: 114439

114439

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 3/05/14

Required Date: 3/19/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149C0332R

Purchased

No

100

Each

7,740.000

3

6

NAS1149C0332R

WASHER

**

3

29

14/04/11

* *

Location

Loc Qty

Loc Code

GA

128591

1125

125654

1125

st510

6615

m126319

89

m127306

2500

m127410

3000

m127831

1026

D2622-120C

Manufactured

No

110

Each

162.0000

1

2

D2622-120C

Step Extrusion

**

14-03-05

Location

Loc Qty

Loc Code

HALL

153

105575

41

109575

112

WA003

9

101765

9

D2734

Manufactured

No

110

Each

119.0000

2

4

D2734

Step End Plate

**

14-03-06

Location

Loc Qty

Loc Code

WA003

119

105712

59

99709

60

4

Picklist Print

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Work Order ID: 114439

114439

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 3/05/14

Required Date: 3/19/14

Start Qty: 2.00

Required Qty: 2.00

D3459-1 Manufactured No 110 Each 16.0000 2 4

D3459-1

Float Step Mounting Plate

**

14-03-06

Location	Loc Qty	Loc Code
WA003	16	

D3459-3 Manufactured No 210 Each 34.0000 2 4

D3459-3

Float Step Mounting Plate

**

14-03-06

Location	Loc Qty	Loc Code
WA003	34	
110702	2	
113052	20	
113241	12	

MS27039C1-07 Purchased No 210 Each 56.0000 3 6

MS27039C1-07

screw

**

3 28 14/04/11

Location	Loc Qty	Loc Code
ST308	56	
124580	6	
m127305	50	

NAS1329C3KB130 Purchased No 210 Each 74.0000 3 6

NAS1329C3KB130

insert

**

3 28 14/04/11

Location	Loc Qty	Loc Code
FP001	74	
m126410	24	
m127836	50	

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Shop Packet Print

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Picklist Print

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Work Order ID: 114439

114439

Parent Item: D2842-042

D2842-042

Parent Item Name: Step Assembly RH, 206 Float

Start Date: 3/05/14

Required Date: 3/19/14

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3L

Purchased

No

210

Each

362.0000

3

6

***NAS1515H3I ***

Washer

3

20

14/04/14

*** ***

Location

Loc Qty

Loc Code

FG

36

102472

36

ST297

326

m127831

326

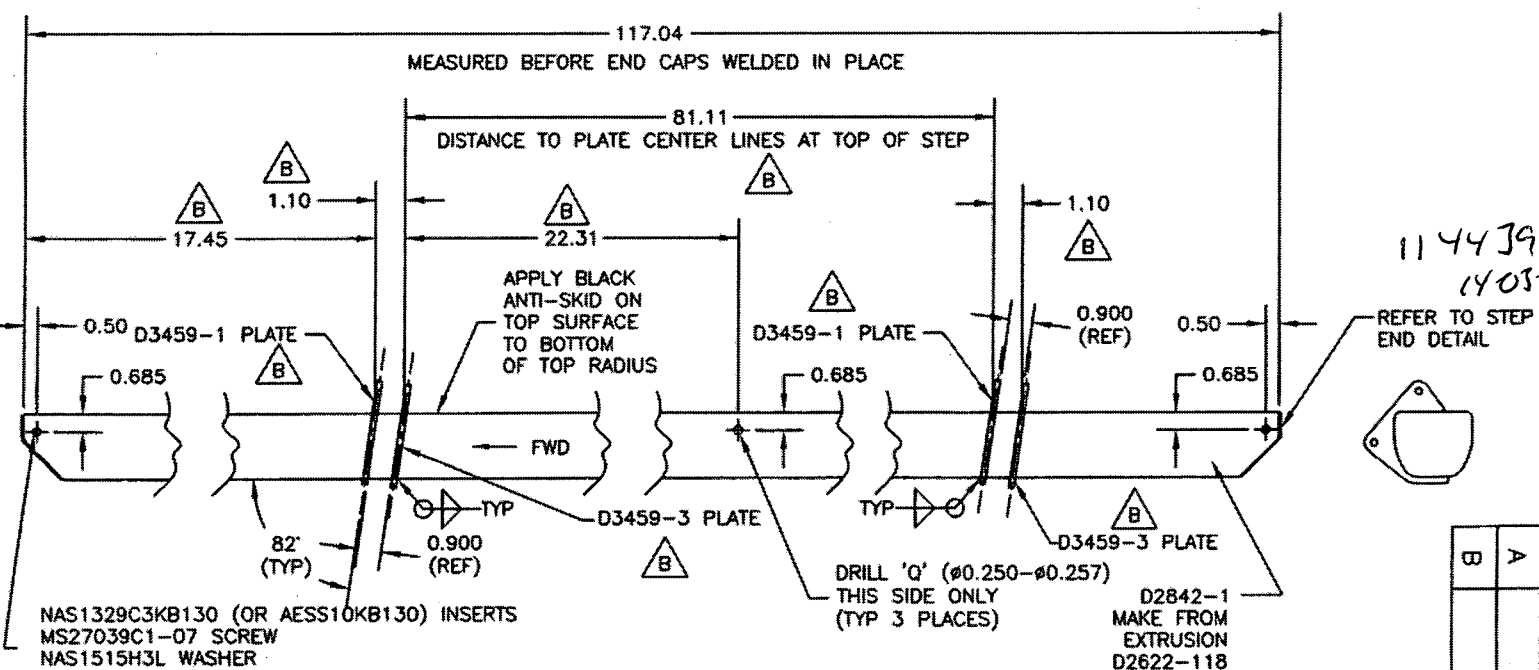
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Shop Packet Print

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DART

114439 MCD
1405-05



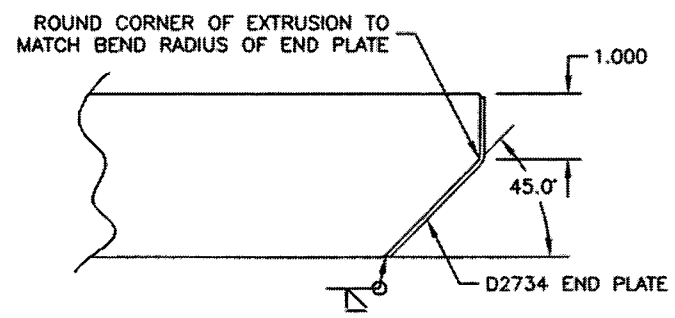
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY
		SCALE NTS
		REV. B
		SHEET 1 OF 1
		RE-DESIGN, ADD D3459-1/-3

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05-4-14
RELEASED